

Stock

Work Order ID 134836

134836

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July 21, 2015 8:28:05 PM

Item ID: D117-1006-012 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: BK117 Bubble Window RH
 Start Date: 7/21/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/28/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: DA Date: 15-7-21 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D117-1006	B								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D117-1006-012	CHG 002							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

SH 15-07-29

DAS
27
9-89

DAS
27
9-89

DAS
28
9-89

JUL 29 2015

8 30/07/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 134836

134836

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Item ID: D117-1006-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: BK117 Bubble Window RH

Start Date: 7/21/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/28/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D117-1006-012 Location: FG106								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

AUG 17 2015

AUG 17 2015

MS 8-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Work Order ID: 134836

134836

Parent Item: D117-1006-012

D117-1006-012

Parent Item Name: BK117 Bubble Window RH

Start Date: 7/21/2015

Required Date: 7/28/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev. A New Issue 14/03/24 DL

IPP REV:B

14.06.25 AS PER IIN REV.B DD VERF:JLM

IPP REV:C 14.12.18

AS PER chg003 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

LN9139M4X12

Purchased

No

Each

98.0000

2

I N9139M4X12

SCREW

**

DAS
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

ST554

98

m129319

98

D3802-1-180

Manufactured

No

110

Each

0.0000

1

1

D3802-1-180

Window Seal - 180"

**

DAS
27
9-89

DAS
26
9-89

D3932-1

Manufactured

No

110

Each

18.0000

2

2

D3932-1

Snap Vent

**

DAS
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

ST077A

18

55837

13

88149

5

D5034-2

Manufactured

No

110

Each

0.0000

1

1

D5034-2

Bubble Window

**

DAS
27
9-89

DAS
26
9-89

D5093-041

Manufactured

No

110

Each

2.0000

1

1

D5093-041

Door Bracket Assembly

**

DAS
27
9-89

DAS
26
9-89

Location

Loc Qty

Loc Code

ST147

2

121331

2

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Work Order ID: 134836

134836

Parent Item: D117-1006-012

D117-1006-012

Parent Item Name: BK117 Bubble Window RH

Start Date: 7/21/2015

Required Date: 7/28/2015

Start Qty: 1.00

Required Qty: 1.00

D5094-041

Manufactured No

110

Each

3.0000

1

1

D5094-041

Post Bracket Assembly

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST147

3

131227

3

D5107-1

Manufactured No

110

Each

9.0000

1

1

D5107-1

Placard

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST148

9

121826

9

D5115-1

Manufactured No

110

Each

9.0000

1

1

D5115-1

Door Prop

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST366

9

121302

9

AN3-7A

Purchased No

110

Each

78.0000

45

45

AN3-7A

Bolt

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST338a

50

m132763

50

ST349

28

131420

28

m132803

19
20

Picklist Print

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Work Order ID: 134836

134836

Parent Item: D117-1006-012

D117-1006-012

Parent Item Name: BK117 Bubble Window RH

Start Date: 7/21/2015

Required Date: 7/28/2015

Start Qty: 1.00

Required Qty: 1.00

LN9355-6X40

Purchased

No

110

Each

44.0000

2

2

I N9355-6X40

BOLT

DAS
26
9-88

Location

Loc Qty

Loc Code

ST554

44

m129319

44

110

Each

1,820.000

90

90

NAS1149D0363J

Purchased

No

NAS1149D0363.J

Washer

DAS
26
9-88

Location

Loc Qty

Loc Code

CA

569

m130799

569

GA

1059

m128429

134

m132677

925

ST269

192

m126319

7

m131618

1

m132317

184

Picklist Print

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Work Order ID: 134836

134836

Parent Item: D117-1006-012

D117-1006-012

Parent Item Name: BK117 Bubble Window RH

Start Date: 7/21/2015

Required Date: 7/28/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

1,216.000

45

45

MS21042L3

Nut

DAS
27

DAS
26

JUL 29 2015

JUL 26 2015

Location

Loc Qty

Loc Code

FP001

393

M130922

393

GA

355

M131317

355

ST305

468

116549

12

126333

49

M128754

2

M132123

17

M132382

388

45

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Shop Packet Print

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4.0 WEIGHT AND BALANCE

The following is the weight of the D117-1006-012 Bubble Window kit. It is the responsibility of the installer to account for the weight and balance of all removed parts.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D117-1006-012 Bubble Window Kit	6.89 lb 2.1 kg	44.8 in 1.1 m	308 in-lb 2.3 m-kg	112.9 in 2.9 m	778 in-lb 6.1 m-kg

5.0 PARTS LIST

Qty -012	Part Number	Description
X	D117-1006-012	BUBBLE WINDOW KIT
1	D3802-1-180	SEAL
2	D3932-1	SNAP VENT
1	D5034-2	BUBBLE WINDOW
1	D5093-041	DOOR BRACKET ASSY
1	D5094-041	POST BRACKET ASSY
1	D5107-1	PLACARD
1	D5115-1	DOOR PROP
45	AN3-7A	BOLT
2	LN9139-0412	SCREW
2	LN9355 6X40	BOLT
90	NAS1149D0363J	WASHER (AN960JD10)
45	MS21042L3	NUT
1	27465A315	DRILL BIT FOR PLASTICS